

Date: Tuesday, 30/09/2008 8:54:17 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP SPACER
Job Number : 42344A	
Estimate Number : 10375	
P.O. Number :	Part Number : D30651
This Issue : 30/09/2008 S.O. No. :	Drawing Number : D3065 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 41445A	Material :
Written By :	Due Date : 15/10/2008 Qty: <u>100</u> <u>50</u> <u>80</u> Um: Each
Checked & Approved By : <u>JUL 08.9.30</u>	
Comment : Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est:D 06.04.25 Water jet EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1300 sf(s)/Unit Total : 6.4995 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040) Batch: 107572 HB 8-10-23

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3065
 Dwg Rev: B HB 8-10-23
 Prog Rev: B
 2-Deburr as required HB 8-10-23

(64)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-10-23

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/10/24 664 counters

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary.

n/a Done at step #2.2
8/10/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 30/09/2008 8:54:17 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 42344A

Part Number: D30651

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Bend as per Dwg D3065

8/10/29

(64)

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5 08/10/29 (64)

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9/10/30

(64)

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT CHEMICAL CONVERSION COAT

FD 08/10/30

(64)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5/10/30 (64)

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/10/31

Job Completion



MF 08-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42349A
Description: Step Spacer		Part Number: D3065-1
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.252	X			
2.093	+/-0.010	2.094	X			
3.936	+/-0.010	3.936	X			
4.186	+/-0.010	4.190	X			
0.587	+/-0.010	.589	X			
Ø0.128	+0.005/-0.001	.131	X			
R0.125	+/-0.010	.125	X			
3.465	+/-0.010	3.462	X			
Ø1.250	+0.012/-0.001	1.251	X			
0.368	+/-0.010	.363	X			
0.871 (Pitch)	+/-0.005	.871	X			
0.040	+/-0.010	.041	X			

Measured by: JB	Audited by: S	Prototype Approval: n/a
Date: 8-10-23	Date: 08/10/24	Date: 11/11

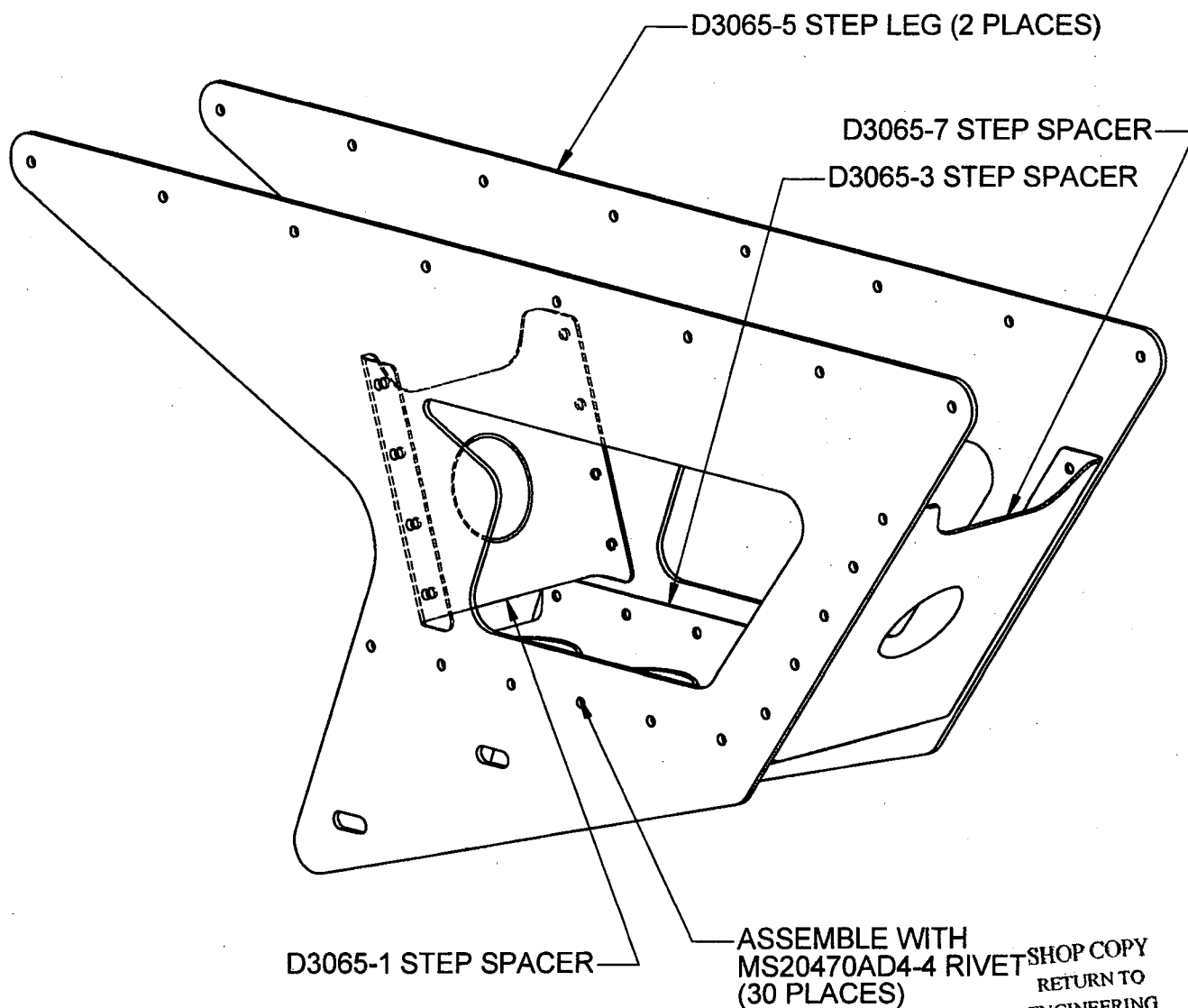
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	07.02.07	Dimension 0.040 added	KJ/JLM	



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



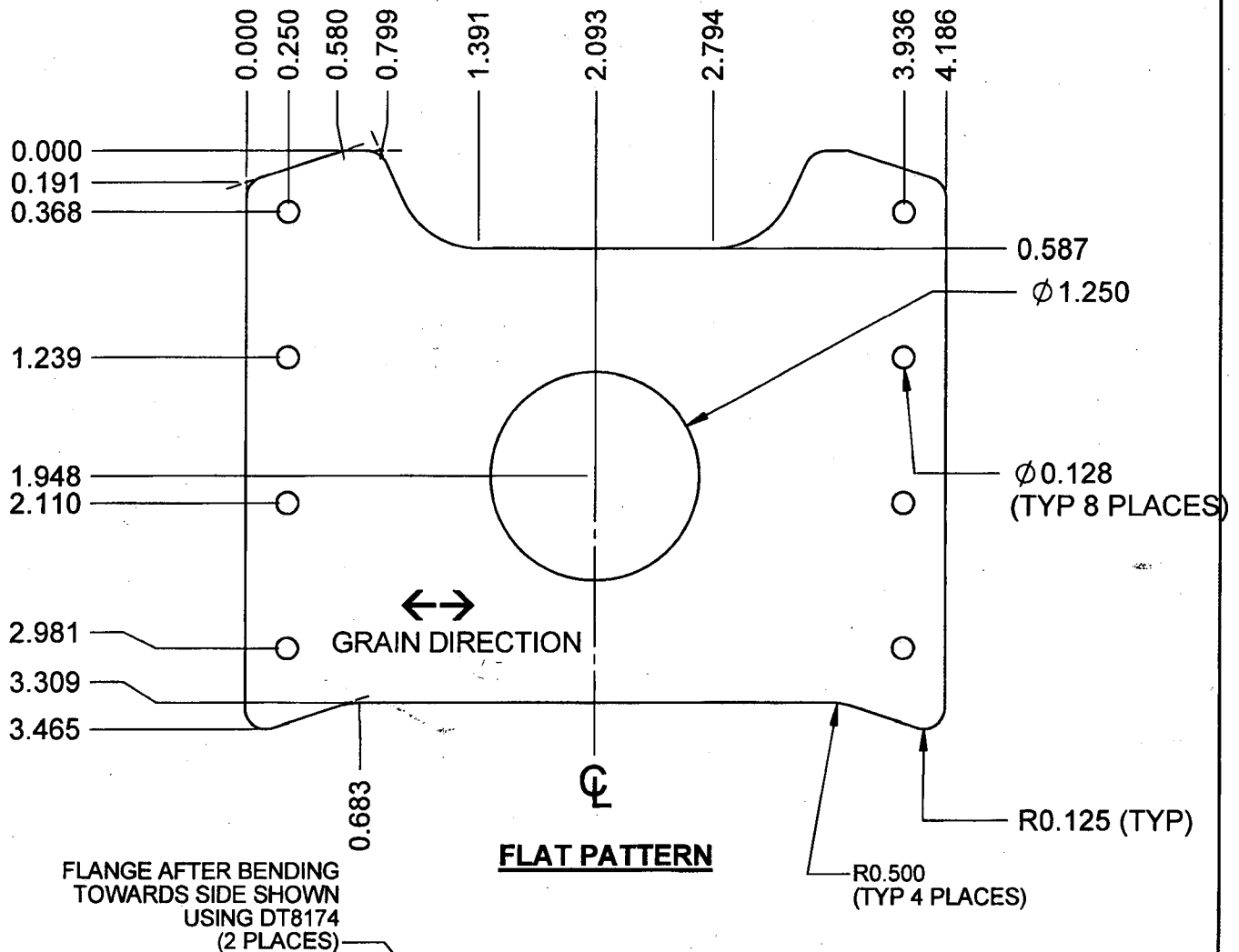
D3065-041 STEP LEG ASSEMBLY

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CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**RELEASED***cl. de-20 #***D3065-1 STEP SPACER****BEND DETAIL**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER

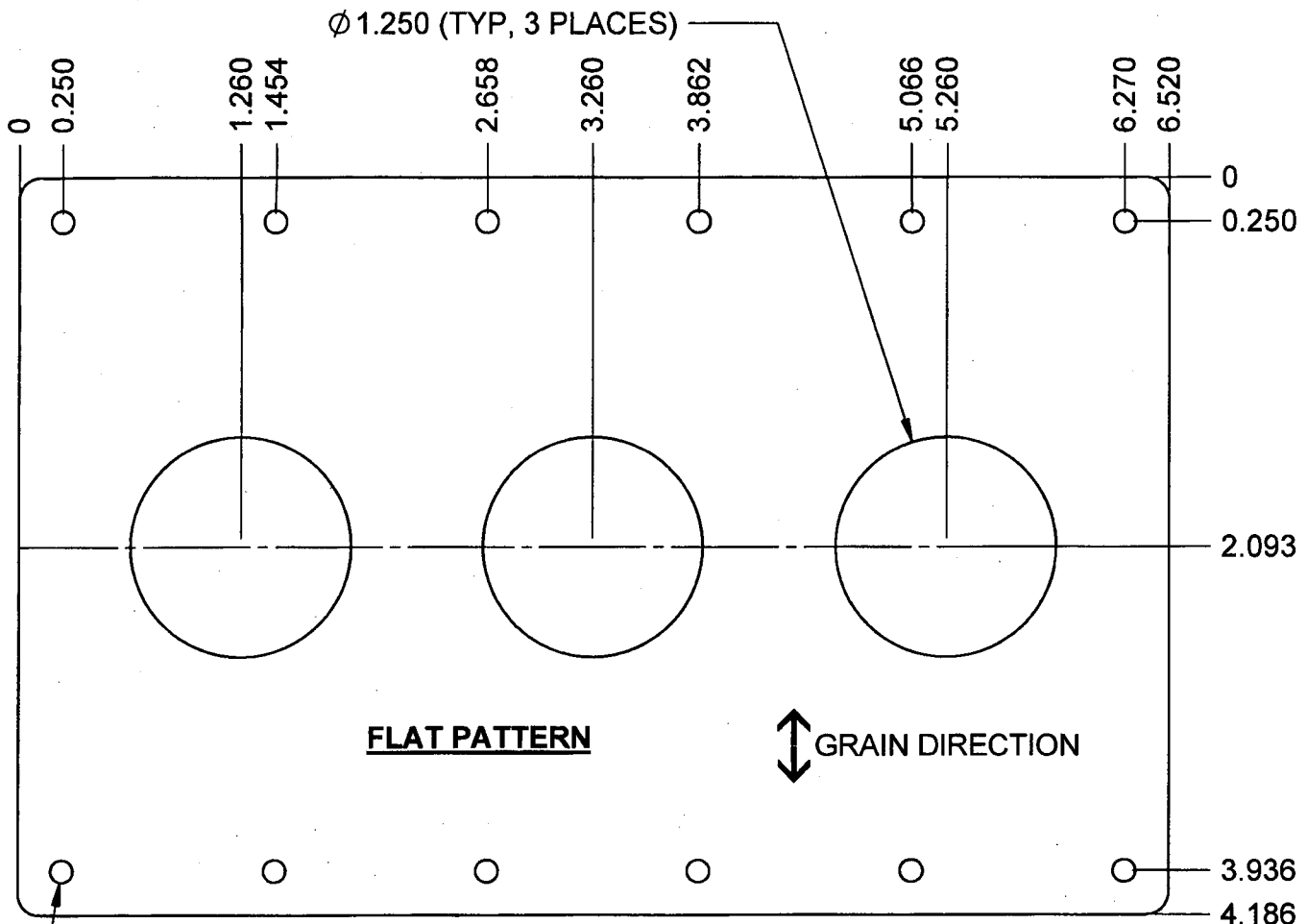
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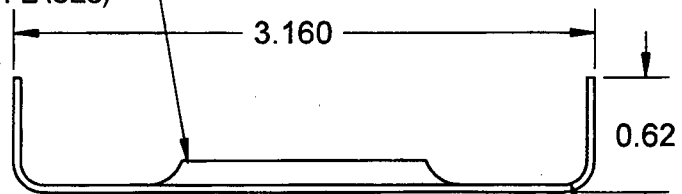
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

**BEND DETAIL**

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D3065-3 STEP SPACER

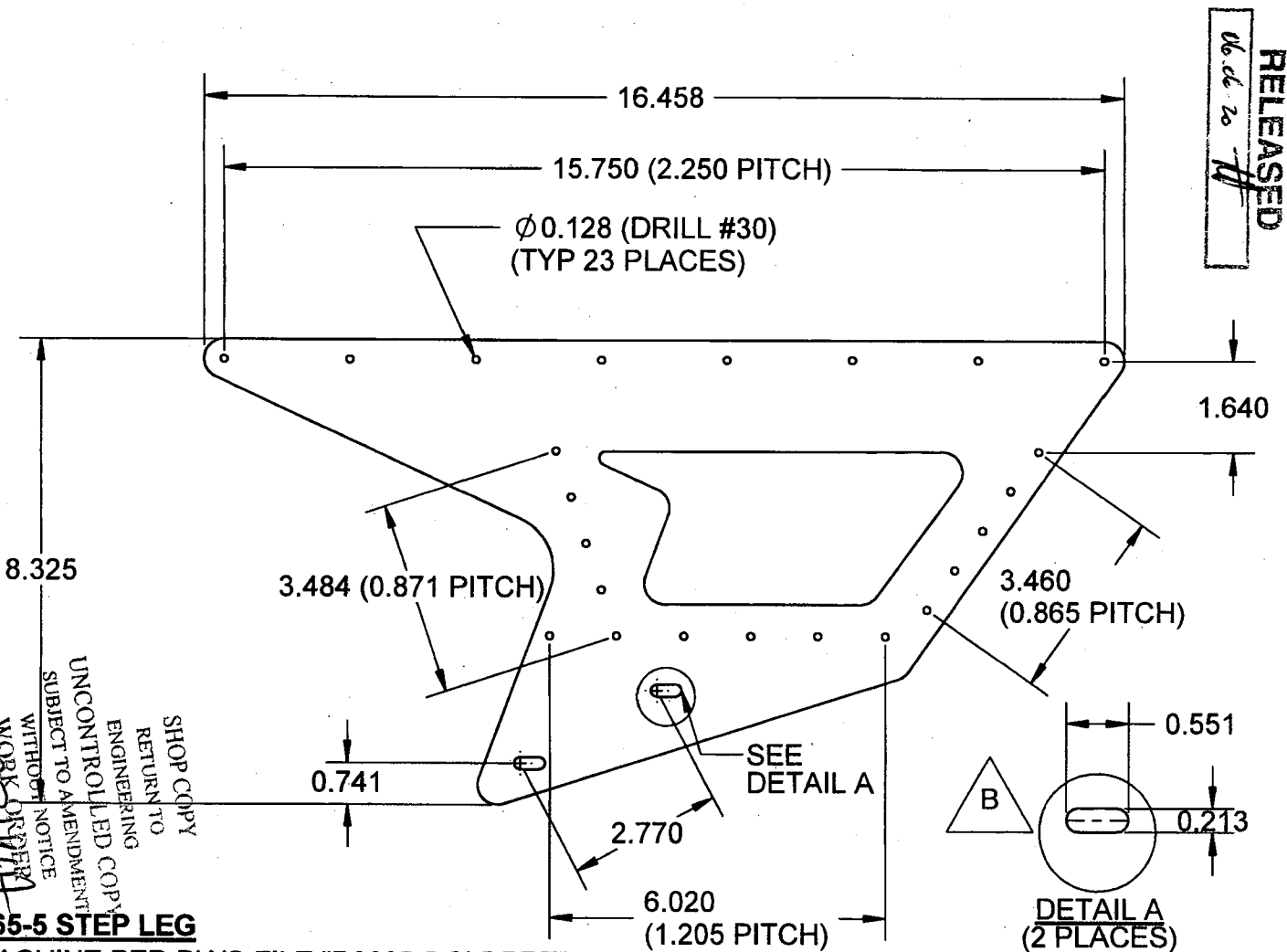
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	CB	DRAWN BY	CB	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	06.05.23	TITLE	D3065	REV. B
			STEP LEG ASSEMBLY	SHEET 4 OF 5
				SCALE 1:3



D3065-5 STEP LEG

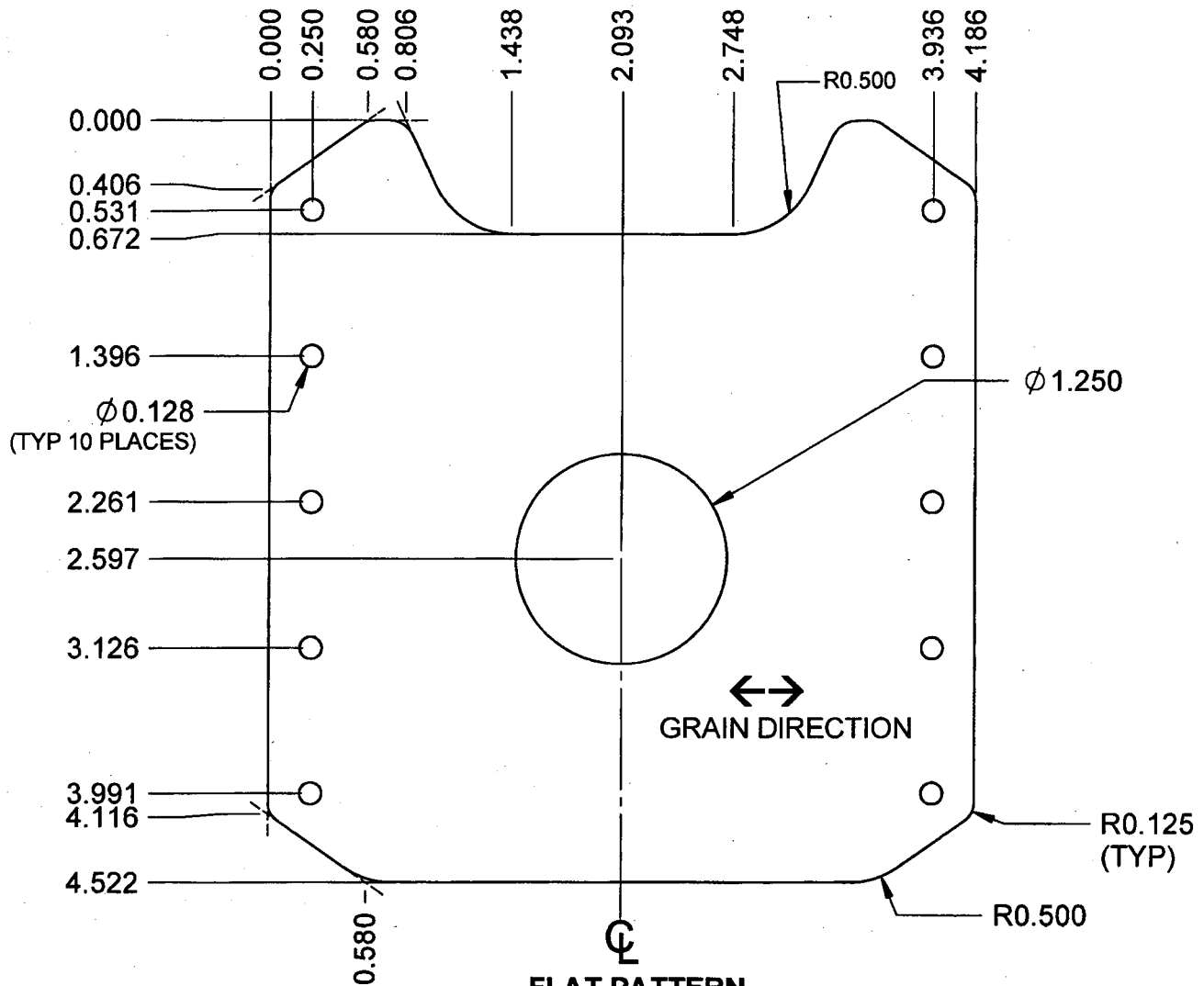
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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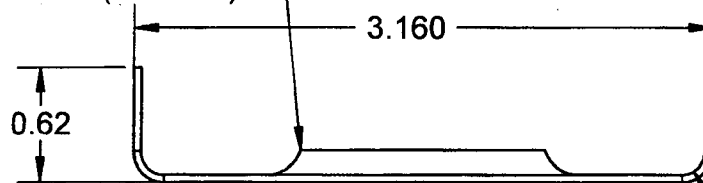
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

**RELEASED***de de 20***D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S-040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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